

Work Order ID 84310

84310

Page 1

Item ID: D2958

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Window

Stop ***NS2***

Start Date: 09/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/05 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2958	Rev E

100. 0.00

100

FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet

1/8" Polycast II
flexiglass.

4 0 Jm
12-5-17

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00

Quality Control

4 0 Jm
12-5-17

120 QC8- Inspect parts - second check 0.00

120

QC Memo 0.00

Quality Control

4 0 Wh
12/05/31
PTO →

Dart Aerospace Ltd

W/O: 84310		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2958 PAR #: _____ Fault Category: Water Jet NCR: Yes No DQA: OK Date: 12/07/10
 Resolution: 1 Disposition: Scrap QA: N/C Closed: OK Date: 12/7/10

NCR: 12-1573		WORK ORDER NON-CONFORMANCE (NCR) 82.01						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/10	120	TOO MANY MARKS FROM WATERJET. BLOWBACK R.C. operator didn't place Plastic Blkdy under mat.	S 12/07/10 02/07/10	SCRAP 1 PART. INFORM WATERJET OPERATOR TO USE PLASTIC GRATING TO AVOID BLOWBACK.	OK 12/06/10	S 12/07/10	S 02/07/10 12/07/10	S 12/07/10
		lack of training						

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg D2958 and Folio FTA005Dwg.
Rev. E Folio Rev. B

x3

12/06/08

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

Check product for scratches mal-formation or any other non conformances.

x3

12/06/08

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control

x3

12/06/08

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

CK 12/7/12

MF
12-07-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

May-09-12 1:38:39 PM

Page 1

Work Order ID: 84310

84310

Parent Item: D2958

D2958

Parent Item Name: Window

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP E: 01.09.25 Done by outside contract SM
IPP F: 07.06.26 Thermoform in house DL
IPP G: 07.09.28 Rev E dwg EC verified by: DD
IPP H: 08.11.24 Step 8 revised per w/o 41134 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	73.2634	2.58	10.86316			

MACRIC 125

1/8" Polycast II Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	73.2634	
110633	3	
117324	0.2467	
117431	10.7967	
119591	59.22	

~~119591~~

Jm
12-5-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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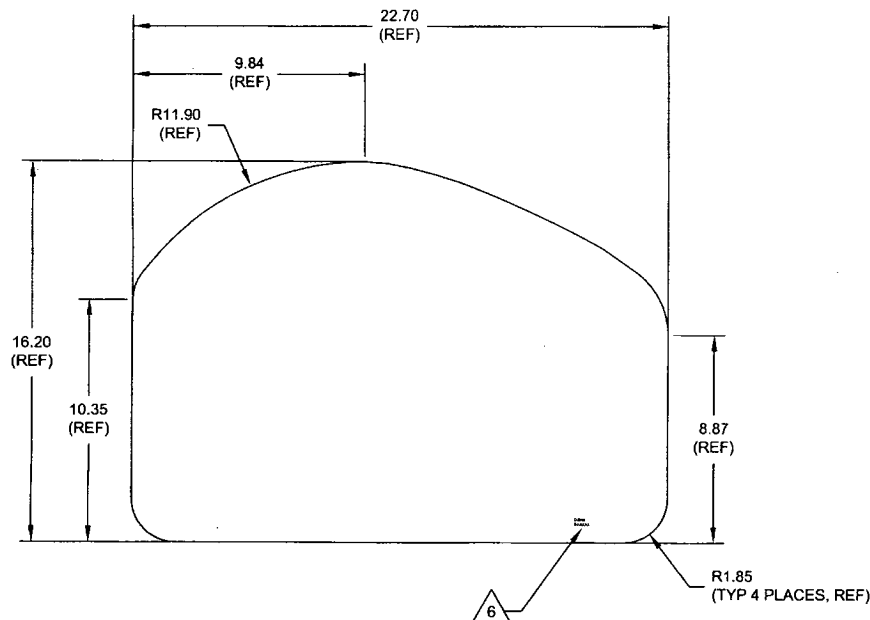
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D2958 FLAT PATTERN

D2958 WINDOW:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D2958" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.58 +/- 0.35 LBS
- 8) MOLD PER DART TOOL DT8567

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84310 MLJ
12/05/09

RELEASED
07.04.22

REV.	DESCRIPTION	BY	DATE
E	UPDATE DIMS PER PAR 188	DC	07.07.06
D	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
C	REMOVE HOLES, UNIFORMLY SMALLER	CP	01.05.30
B	Ø0.156 HOLES WERE Ø0.141 (NCR 407)	CP	00.02.23
A	NEW ISSUE	CP	00.01.20
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2958 TITLE WINDOW SCALE 1:5 COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
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CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.07.06		

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